

Work Order ID 61338

Wednesday, August 18, 2010 3:27:25 PM

Page 1

Item ID: D3674-041

Accept

Revision ID:

Item Name: BRACKET ASSEMBLY

Setup Start

Stop

Start Date: 8/19/2010 Start Qty: 20.00

Required Date: 8/23/2010 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-18

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3674

Rev A

100

0.00



Bandsaw

Jcaspa Bandsaw

BAND SAW

Memo

Cut blanks: (1.250" x 2.000") 5.400" long

0.00

amf 10/09/22

7

110

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine D3674-1 as per Folio FA732 and Dwg D3674 Identify as D3674-
1□2-Deburr□3-Scribe batch number

0.00

amf 10/09/27

6

1

PTO

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00


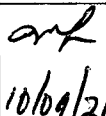
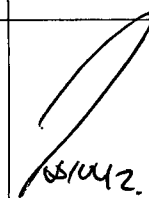
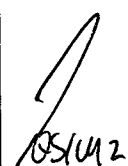
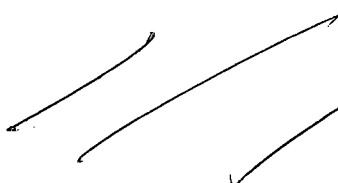
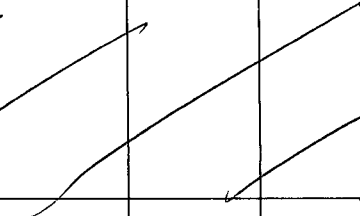
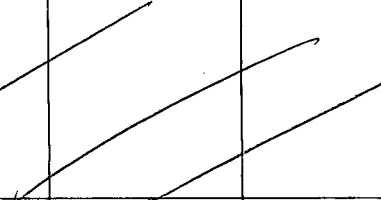
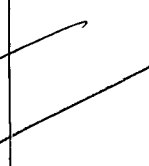
amf 10/09/27

6

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3674-041 PAR #: _____ Fault Category: machining NCR: Yes No DQA: 2 Date: 10/09/27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7/1 Date: 10/09/30

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/09/26	110	1 part scrap, the part more during the machining R.C. poor tooling, the process Process Dial end mill used & pulled up the part, instead of cutting. R.C. Tooling.		scrap and destroy no replace no matt.	 10/09/26	L.A. 10/09/27		S 10/09/27
								S 10/09/27

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 61338

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Page 3

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Revision ID:

Stop

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Start Date: 8/19/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 8/23/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location 246A

0.00



Packaging

Memo

0.00

Packaging

10/19/29 sf GR

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/30 dj
mt 10-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 18, 2010 3:27:24 PM

Page 1

Work Order ID: 61338

Parent Item: D3674-041

Parent Item Name: BRACKET ASSEMBLY

Start Date: 8/19/2010

Required Date: 8/23/2010

Start Qty: 20.00

Required Qty: 20.00


Comments: IPP Rev:A New Issue 08-04-25 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3121-21		Manufactured	No			140	Each	43.0000	1	20			
													
Bolt													


Location	Loc Qty	Loc Code
ST235	43	
57376	1	
59044	2	
60493	40	

Handwritten: 8/20/09/28
B61839 (6x)

D3121-241		Manufactured	No			100	Each	30.0000	1	20			
													
Bearing Assembly													

Location	Loc Qty	Loc Code
ST235B	30	
55005	2	
59435	2	
59774	6	
60494	20	

Handwritten: 8/20/09/28
B61840 (6x)

M174B1.250X02.000		Purchased	No			140	f	3.5031	0.55	11.57895			
													
17-4 SS Bar 1.250 x 2.00													

Location	Loc Qty	Loc Code
MAT	3.5031	
114899	3.5031	

Handwritten: M115545 → 2.75'
M115609 → 1.1'

Handwritten: onk 10/09/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61338
Description: Bracket		Part Number: D3674-1
Inspection Dwg: D3674	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.960	+/-0.010	1.964	—		Vern	ML-7
0.750	+/-0.010	.752	—		"	"
0.605	+/-0.010	.605	—		Height-gage	31006
3.380	+/-0.010	3.382	—		"	"
2.430	+/-0.010	2.430	—		Vern	ML-7
0.380	+/-0.010	.381	—		"	"
0.73	+/-0.030	.730	—		"	"
0.95	+/-0.030	.950	—		"	"
2.140	+/-0.010	2.140	—		"	"
2.030	+/-0.010	2.020	—		"	"
4.718	+/-0.010	4.720	—		H-gage	31006
4.590	+/-0.010	4.585	—		H-gage	31006
0.863	+/-0.010	.857	—		Vern	ML-7
0.130	+/-0.010	.131	—		"	"
4.600	+/-0.010	4.610	—		"	"
4.880	+/-0.010	4.880	—		"	"
5.139	+/-0.010	5.135	—		"	"
R0.25	+/-0.030	R.250	—		Radius-gage	REF.
0.080	+/-0.010	.080	—		Vern	ML-7
0.300	+/-0.010	.300	—		"	"
30°	+/-0.5°	30°	—		Comb-square	ML-CBB
Ø0.573	+/-0.010	Ø.573	—		Vern	ML-7
0.720	+/-0.010	.728	—		"	"
0.345	+/-0.010	.350	—		Vern	ML-7
Ø0.392	+0.002/-0.000	Ø.3938	—		Micro	ML-8
2.173	+/-0.010	2.173	—		Vern	ML-7
3.135	+/-0.010	3.135	—		"	"
3.963	+/-0.010	3.963	—		"	"
4.365	+/-0.010	4.365	—		"	"
0.664	+/-0.010	.665	—		"	"
100°	+/-0.5°	100°	—		N/A	N/A
0.076	+/-0.010	.078	—		Vern	ML-7
0.200	+/-0.010	.200	—		"	"
0.200	+/-0.010	.200	—		"	"
R0.10	+/-0.030	R.100	—		"	"
0.032	+0.000/-0.010	.031	—		Depth-gage	ML-05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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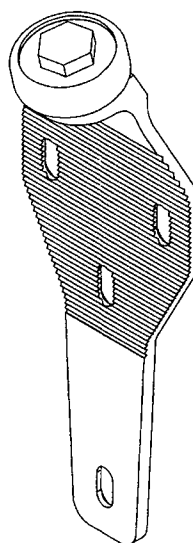
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

QTY -041	PART NUMBER	DESCRIPTION
X	D3674-041	ROLLER BRACKET ASSEMBLY
1	D3121-21	BOLT
1	D3121-241	BEARING ASSEMBLY
1	D3674-1	BRACKET



D3674-041 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs
- 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

A	NEW ISSUE	AJS	08.03.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ABT	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3674	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ROLLER BRACKET ASSEMBLY	NTS
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08.06.26/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

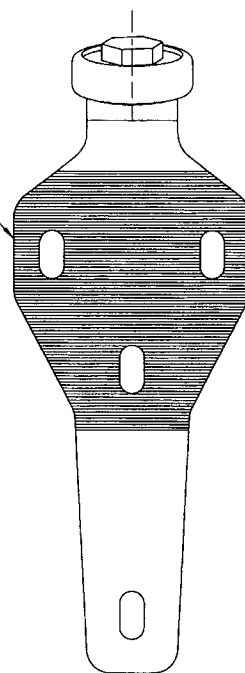
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3674-1 BRACKET



D3674-041 BRACKET ASSEMBLY

8
D3121-21 BOLT

D3121-241 BEARING ASSEMBLY



#61338

RELEASED
08-08-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3674	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ROLLER BRACKET ASSEMBLY	
DATE	08.03.26	NTS	
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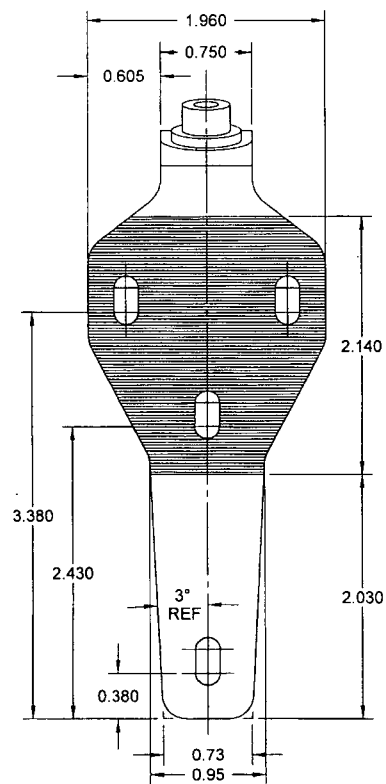
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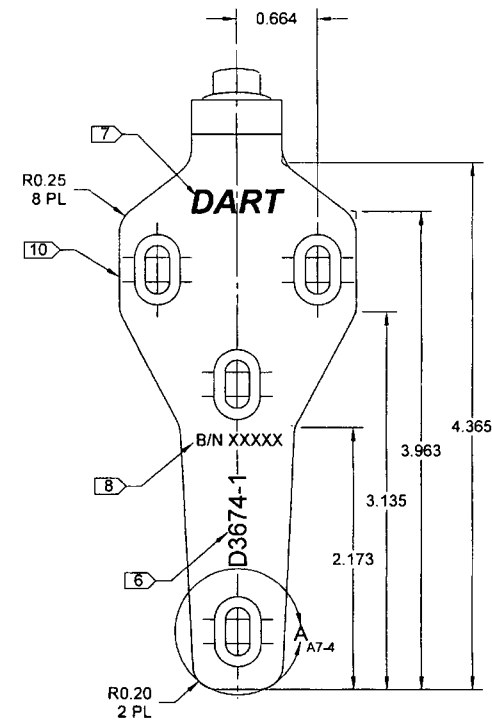
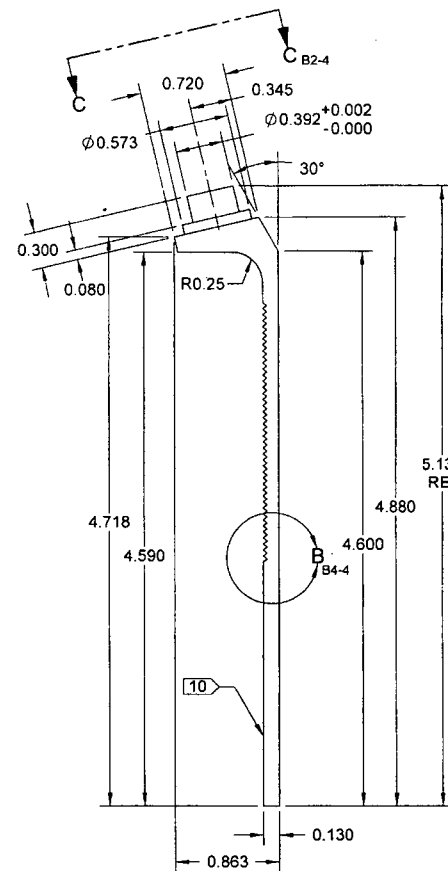
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NOTE: Date & initial all entries



D3674-1 BRACKET



NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
(REF. DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-1" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: ENGRAVE DART LOGO WITH 0.20 HIGH LETTER TO A
MAXIMUM DEPTH OF 0.010 IN AREA SHOWN
- 8) IDENTIFICATION: SCRIBE DART B/N USING VIBRATING STYLUS
- 9) WEIGHT: 0.03 lbs
- 10) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3674	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ROLLER BRACKET ASSEMBLY	NTS
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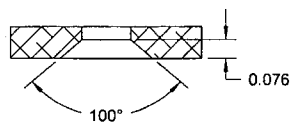
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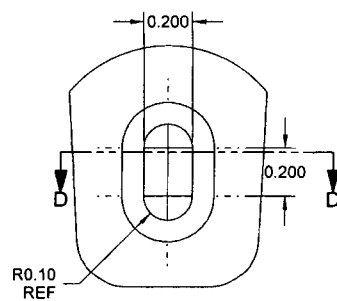
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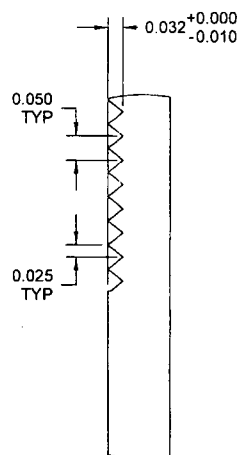
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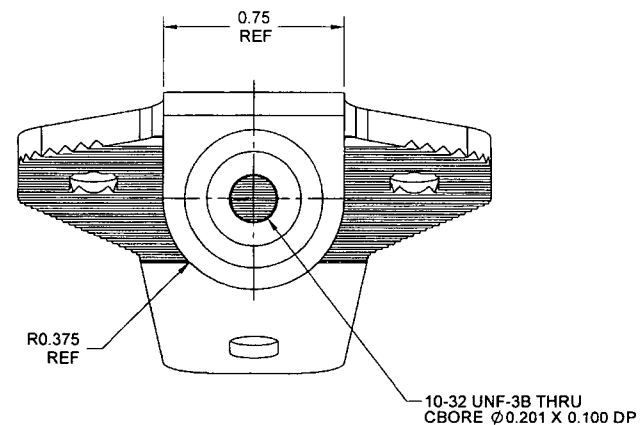
SECTION D-D



DETAIL A B2-3
SCALE 2X
(SLOT DETAIL 4PL)



DETAIL B C4-3
SCALE 4X
(RIDGE DETAIL)



VIEW C-C D3-3
SCALE 2X

RELEASED
08-06-26

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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